

Work Order ID 163150

Thursday, June 22, 2017 10:03:12 AM

D 4822-1
B 163150

163150

Page 1

Item ID: D4822-1

Revision ID:

Item Name: Upper Deflector, LH

Start Date: 7/3/2017 Start Qty: 5.00

Required Date: 8/8/2017 Req'd Qty: 5.00

Reference: SCHEDULED/C

REV C

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

JUN 22 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4822

C

100

0.00

100

Bandsaw

Jeaspa Bandsaw

Memo

CUT AT 32.00" LONG

4.93

JUN 23 2017

DAS
13
9-89

matilat wejay

110

0.00

110

Outsource5

Outsource process - Machining

Memo

ISSUE P/O:

POSSIBLE SUPPLIER: WEJAY

1 BLANK MAKES 2 PARTS

0.00

JUN 23 2017

DAS
13
9-89

Certificate of conformaty required

Work Order ID 163150***163150***

Page 2

Thursday, June 22, 2017 10:03:12 AM

Item ID: D4822-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Deflector, LH
Start Date: 7/3/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/8/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging	Memo	0.00							
Packaging									
117	QC6- All purchased or subcontracted products	0.00							
117									
QC	Memo	0.00							
Quality Control									
120		0.00							
120									
Outsource4	Memo	0.00							
Outsource process - Anodize	HARD ANODIZE IAW MIL-A-8625 TYPE 3 COLOUR BLACK								
	PRIME AS PER DWG NOTE #2								

5x 8017-7-18

5

DAS
38
9-89

JUL 21 2017

5

DOB 2/17/27

PO 37223

Work Order ID 163150

163150

Page 3

Thursday, June 22, 2017 10:03:12 AM

Item ID: D4822-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Deflector, LH
 Start Date: 7/3/2017 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 8/8/2017 Req'd Qty: 5.00 *5* Customer:
 Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
122 *122* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				5			DAG 38 9-89 AUG 15 2017
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				5			DAG 38 9-89 AUG 15 2017
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: CCK042 Memo	0.00 0.00				5	125	1708-15	

Work Order ID 163150***163150***

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Thursday, June 22, 2017 10:03:12 AM

Item ID: D4822-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Upper Deflector, LH
Start Date: 7/3/2017 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 8/8/2017 Req'd Qty: 5.00 ***5*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190							DAS 21 9-89	AUG 21 2017	
QC	Memo	0.00							
Quality Control									

DAS
21
9-89

AUG 16 2017

Picklist Print

Thursday, June 22, 2017 10:03:12 AM

Page 1

Work Order ID: 163150

163150

Parent Item: D4822-1

D4822-1

Parent Item Name: Upper Deflector, LH

Start Date: 7/3/2017

Required Date: 8/8/2017

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 13-04-19 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4822-1P		Purchased	No			110	Each	0.0000	1				
D4822-1P									**				
Upper Deflector, RH													
M7075T6B4.000X4.000		Purchased	No			100	f	15.1407	1.35	7.105263			
M7075T6B4 000X4 000									**				
7075-T6 BAR 4.000" X 4.000" CUT AT 32" LONG													

Handwritten: 8/5/17 X SP17-7-18

AUG 16 2017

**DAS
13
9-09**

Location

Loc Qty

Loc Code

MAT024

15.140685

m131552

8.0006

m133930

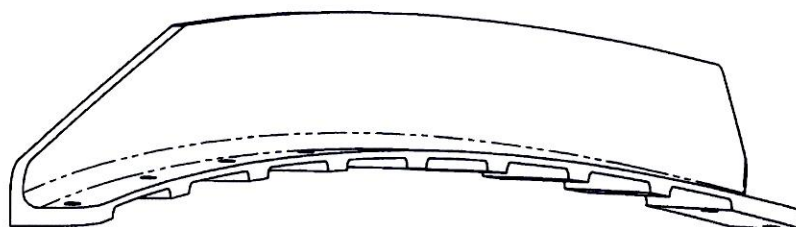
7.140085

Handwritten: ✓

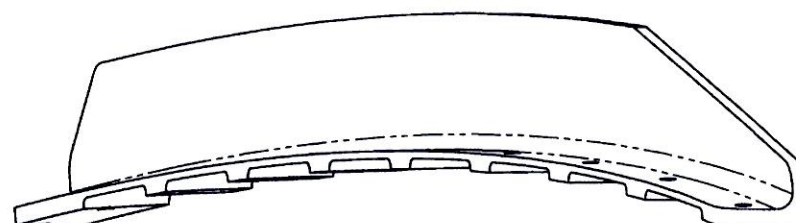
8 7 6 5 4 3 2 1

D D

C C



D4822-1 UPPER DEFLECTOR LH



D4822-2 UPPER DEFLECTOR RH

B B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163150

JUN 22 2017

RELEASED

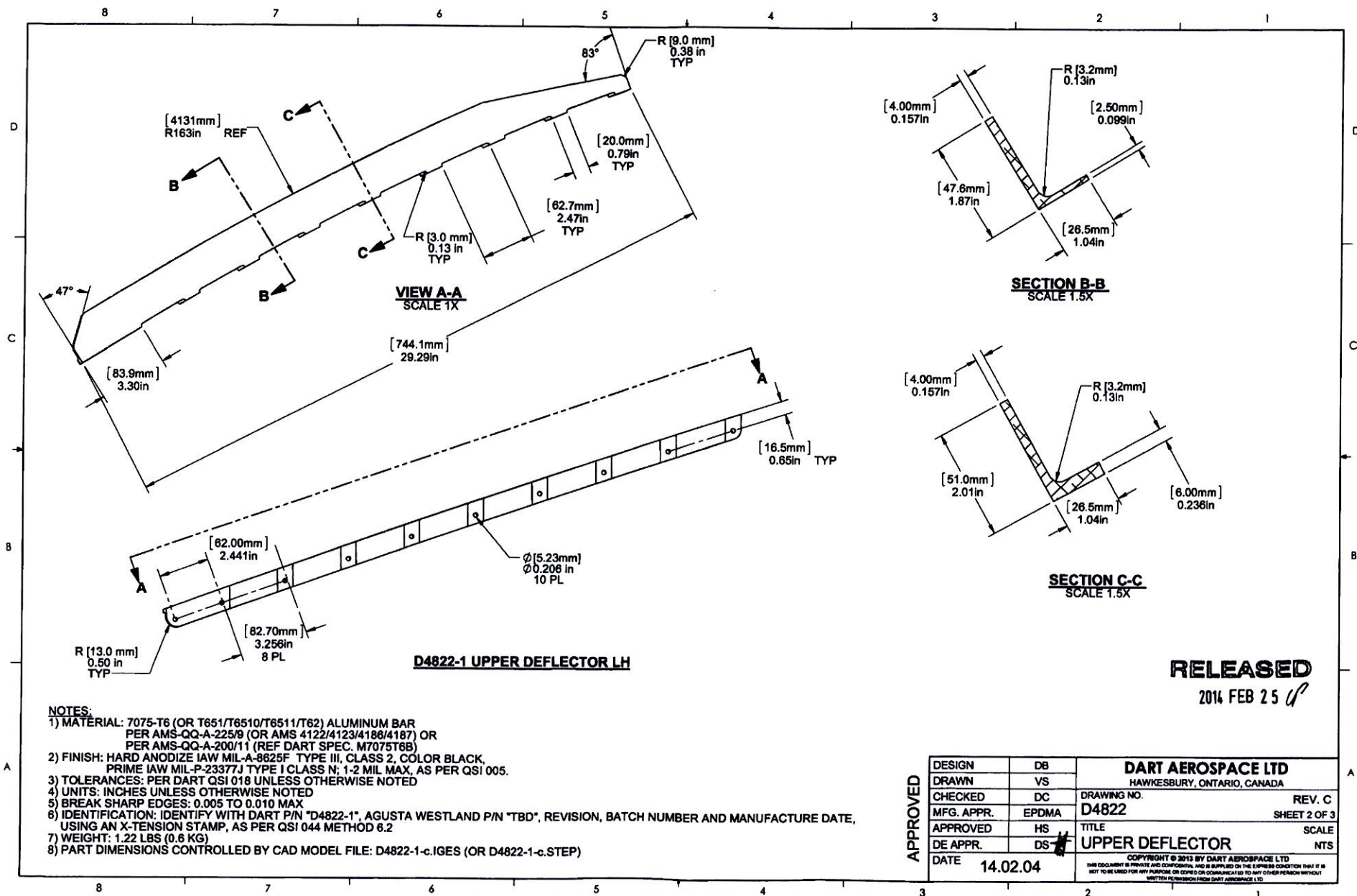
2014 FEB 25
ECW 11-516

A A

C	DRAWING REVISED TO NEW CUSTOMER CAD DATA, RIVET HOLES ADDED	DB	14.02.04
B	CORRECTED WEIGHT	DW	13.09.24
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	EPDMA	D4822	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	UPPER DEFLECTOR	NTS
DATE	14.02.04	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

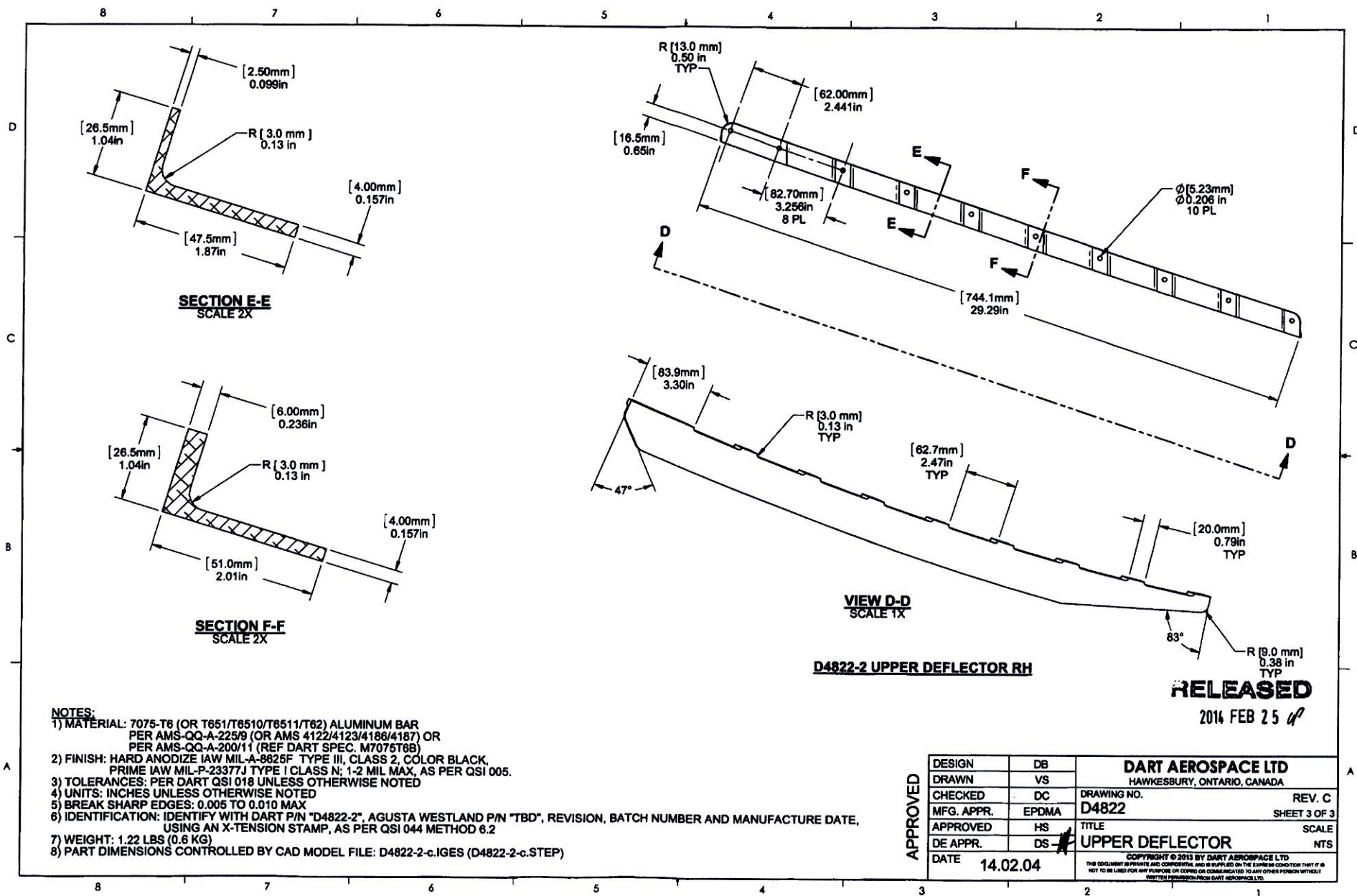
APPROVED

8 7 6 5 4 3 2 1



RELEASED

2014 FEB 25





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36808**

Purchase Order Date 6/23/2017

PO Print Date 7/3/2017

Page Number 1 of 2

Order From : VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4822-1P MANUFACTURE AS PER DWG D4822 REV. C B163150	Upper Deflector, RH LT	7/10/2017 Yes 7/10/2017		5.00 Each	\$1,090.00	\$5,450.00
Line Total:							\$5,450.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/10/2017 No 7/10/2017		1.00	\$0.00	\$0.00
Procurement Quality Clauses							
A004 FAA-PMA/TSO							
A005 RIGHT OF ENTRY							
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)							
A016 PERSONNEL QUALIFICATION							
A024 PROCESS CERTIFICATIONS							
A025 CERTIFICATE OF CONFORMANCE							
A040 NOTIFICATION OF QUALITY ESCAPE							
A042 DART NOTIFICATION BY SUPPLIER							
A043 RETENTION OF QUALITY DOCUMENTS							

Note:

7/3/2017



Packing Slip 38694

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

SOLD TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

SHIP TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. 36808		DATE ORDERED 07/10/17		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED 5	B.O. 0	QUANTITY SHIPPED 5	DESCRIPTION Manufacture upper deflector, LH as per drawing D4822, Rev. C D4822-1P B163150 Required by: July 17, 2017 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <u>[Signature]</u> July 13/17			UNIT PRICE	AMOUNT
						H.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

NO GOODS RETURNED WITHOUT PRIOR AUTHORIZATION

RECEIVED BY _____
DAS
38
9-89
.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

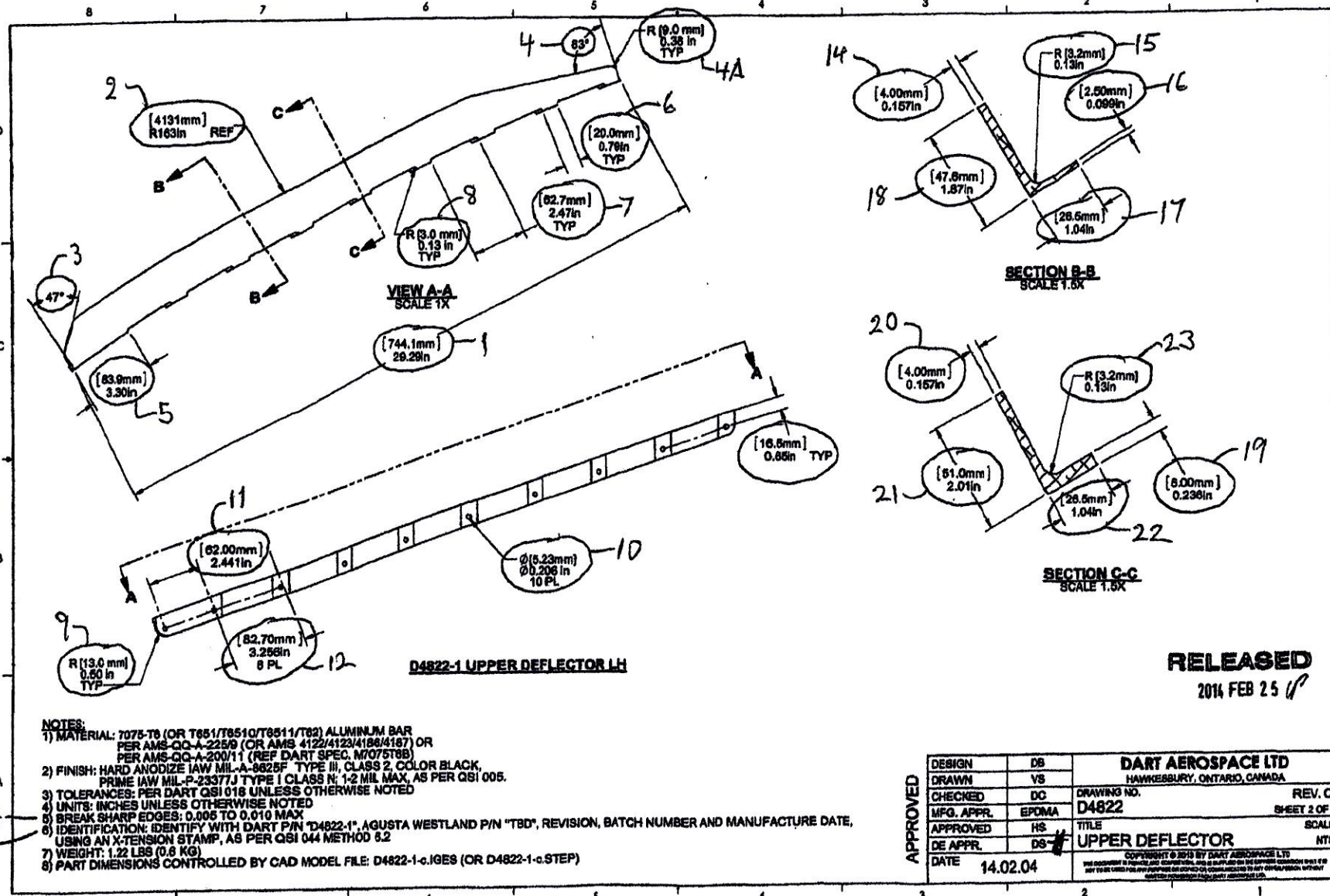
CUSTOMER: Dart Aerospace		DATE: July 13, 2017	
		P.O.# PO36808	
		WEJAY JOB# 38694	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D4822-1P 'Upper Left Hand Deflector' B163150	5	Machined complete per drawing req'ts.	D4822 / rev. C
<u>Note:</u> 1) Each part is tagged with 'Dart' Material Batch number. 2) 1st Article Inspection reports attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,

Clifford Smith

Authorized Q.A. Signatory





600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 38694

PAGE: 1 of 1

CUSTOMER: Dart Aerospace

CUST. P.O.# PO36808

PART No. D4822-1P

DESCRIPTION: Deflector Left Hand

DWG No. D4822

REV. C

E.C.O. --

MATERIAL: Dart supplied material- ref# M133609

INSPECTOR: Cliff Smith

QUANTITY
REC'D: 1

ACCEPT:
1

REJECT:
-

N.C.R.#
-

DATE: July 13, 2017



INSTRUCTIONS, COMMENTS: Standard Tolerances per DART QSI 018 unless otherwise noted
-First Article Inspection-

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	29.29"	View A-A	±.03	2/C6	29.31	1	Accepted
2	R163" ref		±.10	2/D7	Passed	1	Accepted
3	47°		±.5°	2/C8	46.5°	1	Accepted
4	83°		±.5°	2/D5	82.5°	1	Accepted
4A	R 0.38" typ.		±.03	2/D4	R .375 typ.	1	Accepted
5	3.30"		±.03	2/C8	3.313	1	Accepted
6	0.79" typ.		±.03	2/D5	.800- .810	1	Accepted
7	2.47		±.03	2/D5	2.460- 2.475	1	Accepted
8	R 0.13 typ.		±.03	2/C6	R .125 typ.	1	Accepted
9	R0.50" typ		±.03	2/B8	R .500 typ.	1	Accepted
10	Ø0.206 hole thru	10 pl.	+.005/ -.001	2/B5	Ø .208 typ.	1	Accepted
11	2.441"		±.010	2/B7	2.444	1	Accepted
12	3.256" typ.	8 pl.	±.010	2/B7	3.254- 3.260	1	Accepted
13	0.65" typ.	10 pl.	±.03	2/B4	.645- .646	1	Accepted
14	0.157"	Section B-B	±.01	2/D3	.156-.165	1	Accepted
15	R0.13" typ.		±.03	2/D2	R .19 typ. (per e-model)	1	Accepted
16	.099"		±.01	2/D2	.100- .105	1	Accepted
17	1.04"		±.03	2/D3	1.040- 1.044	1	Accepted
18	1.87"		±.03	2/D3	1.873- 1.875	1	Accepted
19	0.236"	Section C-C	±.01	2/B1	.235-.240	1	Accepted
20	0.157"		±.01	2/C3	.156- .164	1	Accepted
21	2.01"		±.03	2/B3	2.010- 2.015	1	Accepted
22	1.04"		±.03	2/B2	1.040- 1.045	1	Accepted
23	R0.13"		±.10	2/C2	R .19 typ. (per e-model)	1	Accepted
24	Deburring	Per note 5	.005-.010	2/A8	Passed	1	Accepted
25	Identification	Per note 6		2/A8	N/A	1	Accepted



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER
Purchase Order ID PO37223

Purchase Order Date 7/26/2017
PO Print Date 7/28/2017

Page Number 1 of 8

Order From : VC-ATG001
A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	162420 Black Anodize and Prime As per dwg 646.3100 Rev N/C	646.3110 channel	7/26/2017 Yes 7/26/2017 8/23/2017		8.00	\$0.00 10.65	\$0.00
						Line Total:	85.60 \$0.00
2	163150 Hard anodize and Prime as per Dwg 4822 REV. C	D4822-1 Upper Deflector, LH	7/26/2017 Yes 7/26/2017		5.00	\$0.00 30.00	\$0.00
						Line Total:	150.00 \$0.00
3	163292 Black Anodize and Prime as per Dwg 647.1500 Rev D	647.1510 Upper Deflector	7/26/2017 Yes 7/26/2017		6.00	\$0.00 20.65	\$0.00

PO Instructions: PRIMER IS SUPPLIED BY DART

Note:

7/28/2017



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 913691

Date: 14-Aug-17

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: 649.4816 Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 21453	Rev: B PO: PO37223	Line: 10
10 ea	Part: 649.4816 Doubler Job: 21457	Rev: B PO: PO37223	Line: 14
5 ea	Part: D4822-1 Upper Deflector, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 21445	Rev: C PO: PO37223	Line: 2
1 ea	Part: ADMINISTRATION FEE Administrative Fee Job: 21467	- Rev: N/A PO: PO37223	Line: 23-24
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>14/8/17</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may Made in Canada.			

Chantal Lavoie

From: Scott Dennis <scott@wejay.com>
Sent: Tuesday, August 15, 2017 4:50 PM
To: Chantal Lavoie
Subject: Fw: Quote

Hi Chantal please see below for Cliff's comments.

Thanks again.

Scott

From: [Clifford Smith](#)
Sent: Tuesday, August 15, 2017 4:33 PM
To: 'Scott Dennis'
Subject: RE: Quote

Hi Scott,

These parts were manufactured as part of our job# 37749 (DART P.O.# 30870), as spares.
The parts were identified with labels as being made from "Dart" material batch/ lot# M133930.

Cliff

From: Scott Dennis [mailto:scott@wejay.com]
Sent: Tuesday, August 15, 2017 3:14 PM
To: Clifford Smith
Subject: Fw: Quote

Hi Cliff, Do we have a record of the material we used for the deflectors that we sent recently?

Scott

From: [Chantal Lavoie](#)
Sent: Tuesday, August 15, 2017 3:00 PM
To: [Scott Dennis](#)
Cc: [Marie Lajeunesse](#)
Subject: RE: Quote

Good afternoon Scott,
Would you be able to advise which batch you took for this po36808. (D4822-1)
Thanks
Chantal

From: Chantal Lavoie
Sent: Friday, June 23, 2017 2:18 PM
To: Scott Dennis <scott@wejay.com>
Subject: RE: Quote

Thank you Scott,
Please see attached for new po36808, could you please advise which batch # you have taken for these parts.
Thanks
Chantal

From: Scott Dennis [<mailto:scott@wejay.com>]
Sent: Thursday, June 22, 2017 4:21 PM
To: Chantal Lavoie <clavoie@dartaero.com>
Subject: Quote

Hi Chantal, Here is the quote for the deflectors. I gave you the 8 piece price for the 5 as we produced some extras a while back and we actually have these in stock.
We could ship them as soon as we get the quality documentation in order.

Thanks again.

Scott Dennis
Wejay Machine Products Co. Ltd.
613-384-1662
scott@wejay.com



Virus-free. www.avast.com